

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023927**Date Inspected:** 23-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

Trial Assembly

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member was identified as OBG CB19. The weld designations reviewed are as follows:

DP3180-001-019~024,031,032,013~018, 027,030,033~040

DP3178-001-009~012,017~020,005~008, 013~016

DP3180-2-001-017~020

DP3178-2-001-009,010

DP3179-2-001-029~035

DP3179-001-064~070,036~056

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Wong Xiang Pin and ABF QA Sha Zhi.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 13AW

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PCMK: SEG3013AH
Weld No: 136,156,166,
Welder: 066674
Weld Repair No. B-WR20967
WPS-345-SMAW-4G(4F)-FCM-Repair-1

Components; OBG 13BE
PCMK: SEG3013P
Weld No: 001
Welder: 066398
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 13AE
PCMK: SEG3013C
Weld No: 047,053
Welder: 066398
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG
PCMK: KP3005-001
Weld No: 001
Welder: 037723
WPS-B-P-2112-FCM-1

Components; OBG
PCMK: KP3005-001
Weld No: 005
Welder: 037723
WPS-B-P-2114-FCM-1

Components; OBG 14E
PCMK: SEG3019X
Weld No: 098
Welder: 058102
WPS-B-P-2212-TC-U4b-FCM-1

This QA Inspector observed the following work in progress for Trial Assembly.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Wong Xiang Pin and ABF QA Sha Zhi.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components; OBG 13CW
PCMK: SEG3015B

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Weld No: 187,111,195

Welder: 070101

WPS-B-T-2233-ESAB

Components; OBG 13AW

PCMK: SEG3020AG

Weld No: 007,010,016

Welder: 037105

WPS-B-T-2132-ESAB

Components; OBG 14W

PCMK: SEG3013AJ

Weld No: 012,034,043,061,016,018,092

Welder: 070101, 037705

WPS-B-T-2233-ESAB

Components; OBG 13AW

PCMK: SEG3013Y

Weld No: 370,372,374,376.

Welder: 066673

Weld Repair No. B-WR19836

WPS-345-FCAW-1F(1G)-ESAB-Repair-1

Components; OBG 13AW

PCMK: SEG3020AG

Weld No: 007,010,016

Welder: 037105

WPS-B-T-2132-ESAB

Components; OBG 13CW

PCMK: SEG3015B

Weld No: 187,111,195

Welder: 037705

WPS-B-T-2233-ESAB

Components; OBG 13CW

PCMK: VP3014-001

Weld No: 007,010,016

Welder: 037105

WPS-B-T-2132-ESAB

Components; OBG 13CW

PCMK: VP3015-001

Weld No: 011,022

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Welder: 068917
WPS-B-T-2132-ESAB

Components; OBG 13CW
PCMK: SEG3015C
Weld No: 098,094,090,082,078,070,066
Welder: 057876
WPS-B-T-2233-ESAB

Components; OBG 13BE
PCMK: LD3028-001
Weld No: 096,097,072,073,048,049
Welder: 055564
WPS-B-T-2132-ESAB

Components; OBG 13AE
PCMK: SEG3007U
Weld No: 265,266,261,262,257,258
Welder: 055564
WPS-B-T-2132-ESAB

Components; OBG 13CE
PCMK: SEG3011B
Weld No: 092,093,096,097,100,101,104,105
Welder: 050242
WPS-B-T-2132-ESAB

Components; OBG 14E
PCMK: SP3117-001
Weld No: 022~029
Welder: 050242
WPS-B-T-2132-ESAB

Components; OBG 13CW
PCMK: VP3016-001
Weld No: 001~004
Welder: 055491
WPS-B-T-2232-ESAB

Components; OBG 13CW
PCMK: VP3017-001
Weld No: 001~003
Welder: 055491
WPS-B-T-2232-ESAB

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Components; OBG 13CW

PCMK: VP3007-001

Weld No: 011,023

Welder: 055491

WPS-B-T-2232-ESAB

Components; OBG 13CW

PCMK: VP3008-001

Weld No: 001,014

Welder: 055491

WPS-B-T-2232-ESAB

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

“No relevant conversations.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt,Kelly	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
